



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4686-1**Job Sheet 190783****Part No:** D4686-1**Job Qty:** 40 pcs**Part Name:** Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/14/19**Job Tracking No:****Due Date:** 3/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: D4686 REV.B IPP REV:A 13.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 13-06-15 NEW LENGHT JLM
VERIFIED BY:DD IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs		3/18/19	0.01	1.17	Hardinge - 1		19/03/20
120	QC 8	40 pcs		3/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		19/03/20
							QC 8 - 47		
122	Outsource - 1 - Heat Treat	40 pcs		3/18/19			MEI001-VC	15	03/20/2019 PL
124	Packaging 2-1 - Receive - B4B	40 pcs		3/18/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		

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					Packaging 2 - 7 - B4B						
					Packaging 2 - 8 - B4B						
					Packaging 2 - 9 - B4B						
					Packaging 2 - 10 - B4B						
					Packaging 2 - 11 - B4B						
					Packaging 2 - 12 - B4B						
					Packaging 2 - 13 - B4B	DP APR 04 2019					
					Packaging 2 - 14 - B4B						
					Packaging 2 - 15 - B4B						
					Packaging 2 - 16 - B4B						
					Packaging 2 - 17 - B4B						
					Packaging 2 - 18 - B4B						
					Packaging 2 - 19 - B4B						
					Packaging 2 - 20 - B4B						
					Packaging 2 - 21 - B4B						
					Packaging 2 - 22 - B4B						
					Packaging 2 - 23 - B4B						
					Packaging 2 - 24 - B4B						
					Packaging 2 - 25 - B4B						
					Packaging 2 - 26 - B4B						
					Packaging 2 - 27 - B4B						
					Packaging 2 - 28 - B4B						
					Packaging 2 - 29 - B4B						
					Packaging 2 - 30 - B4B						
					Packaging 2 - 31 - B4B						
					Packaging 2 - 32 - B4B						
					Packaging 2 - 33 - B4B						
					Packaging 2 - 34 - B4B						
					Packaging 2 - 35 - B4B						
					126 QC 6		40 pcs	3/18/19	0.00 0.00	QC 6 - 42	
										QC 6 - 9	
										QC 6 - 68	DAS
										QC 6 - 61	APR 08 2019 68 9-89
					130 Handfinish - 1-1 Chemical- B4B		40 pcs	3/18/19	0.00 1.00	Handfinish - 1 - 1 - B4B	
										Handfinish - 1 - 2 - B4B	
Handfinish - 1 - 3 - B4B											
Handfinish - 1 - 4 - B4B											
Handfinish - 1 - 5 - B4B											
Handfinish - 1 - 6 - B4B											
Handfinish - 1 - 7 - B4B											
Handfinish - 1 - 8 - B4B											
Handfinish - 1 - 9 - B4B											
Handfinish - 1 - 10 - B4B	D.R 19/09/09										
Handfinish - 1 - 11 - B4B											
Handfinish - 1 - 12 - B4B											
Handfinish - 1 - 13 - B4B											
Handfinish - 1 - 14 - B4B											
Handfinish - 1 - 15 - B4B											
Handfinish - 1 - 16 - B4B											
Handfinish - 1 - 17 - B4B											
Handfinish - 1 - 18 - B4B											
Handfinish - 1 - 19 -											
					Plex 2/14/19 1:38 PM Dart.lajeunesse.mari						

				B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	40 pcs	3/18/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 6
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
150	Packaging 3-1 - Stock - B4B	40 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
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					Packaging 3 - 21 - B4B
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					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B

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				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
160 QC 21 - SA	40 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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Part Op 100 - (Hardinge) Machine as per Folio FB164
 Descriptions: 120 - (QC8- Inspect parts - second check)
 122 - 1 (Outsource process - Heat Treat) HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN)
 NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL
 124 - (Receive & Inspect for Damage & Mat'l Certs) ENSURE C OF C IS ATTACH
 126 - (QC6- All purchased or subcontracted products)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Identify as per dwg & Stock Location: _____) ***STOCK IN SKIDTUBE CELL**
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.750W.058	6061-T6 Round Tube .750 X.058W	17.6000 ft (.44 ea)	100-Hardinge - 1	M127067 5092704

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.750W.058	18	36	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.750Inches ± 0.010	0.760 0.740		Reference, Diameter
2	Spacer	0.058Inches ± 0.010	0.068 0.048		Reference
3	Spacer	5.200Inches ± 0.063	5.263 5.138		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S163997



Part: D4686-1

Job No: 190783

Serial No/Batch: S163997

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042942



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Cloutier, Danielle

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042942

PO Date: 3/20/19

Due Date: 4/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190783	D4686-1	Spacer : Various STC's 1 (Outsource process - Heat Treat) HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	-	4/1/19	40 pcs	0 pcs	40 pcs	\$17.18/pcs	\$687.20

Line Item Note ** NEED BACK April 01,2019 **



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Canada

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PURCHASE ORDER

PO042942



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	190611	20NR-08	Lifting Bushing Outsource process - Heat Treat)1-Issue P/O to METCORE; P/O _____ RC 45-48 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH*** ----- Lifting Bushing -I (Outside Processing - Nickel Plate)ssue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N- 290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	4/1/19	12 pcs	0 pcs	12 pcs	\$25.83/pcs	\$309.96

Line Item Note ** PLEASE SHIP TO GROUP ALTECH APRIL 01,2019 **

Grand Total: \$997.16

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
335134	1	135973

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
42942		AL-6061	2019/3/21	CLIENT

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight
40	D4686-1			3,
	(40) D4686-1			
	JOB 190783			

1 BOITE DE CARTON

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 3,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 3,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335134	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42942	Part Class 1	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	10	40,5 - 41,5 %IACS
HARDNESS	60 HREW MIN	10	61,5 - 64 HREW
(916) MESURE EN HR15TW = 63,5-64,5 HR15TW			

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QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	3	D4686-1 (40) D4686-1 JOB 190783 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2019-03-30

APPROUVÉ

MILCO INC.

[illegible]

4381-E74-024-151

4240-104024 MONROVIA KAT WATGOSIST
4240-104024 MONROVIA KAT WATGOSIST

332134	481333
NON DE TRAVAIL	140110
1	140110
CHARGEMENT	140110

TAMM AGRI INC

YFUBB321VAH

TRY AGAIN

Y31U923740/44

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30A92073A TPA0
M3308384 D7C1

215 TEMPORE TVETIO
BOARDOFIA TRAO
MBOFEEA OTI

MAGROGRA	ERIVUJO D ERTIAM	JERETAM	ESORIP MOLIACIPISSAUO	TINIU JO UO EQUANIMMOO
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	1808-1A		t eaeio tieq	✓ 51824

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ДЖИММІ ДЖЕ
547 МОТІОН ОУ БІНАДЖІ

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SDA1a6 B 14-B-04 OF SDA1a6 B 4-B-03 YTWITQUDIMOS
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EDDA 16% B14-2,0N

Dr

33-43-55

CONDUCTIVITY

WEST-010

Dr

MIN XEZH 03

220304

U. 48-5,33 = WTEF PH 13 FRAUSEM (512)

WATER

STANDARD	POIDS	DESCRIPTION
40	3	01688-1
		pour description
		081691 BOL
		01688-1
		BOITE DE CARTON

sinemmo \ 3371ATNEMMO

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3-VUORPPA

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335134	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42942	Part Class 1	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCT	35 - 43 %IACS	10	40.5 - 41.5 %IACS	DAS 68 9-89
HARDNESS	60 HREW MIN	60 KHZ		
		10	61.5 - 64 HREW (916) MESURE EN HR15TW = 63,5-64,5 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	3	D4686-1 (40) D4686-1 JOB 190783 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOLUTION ANNEAL 985F 35 MINS
AGE HARDEN AMBIANT

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335134	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

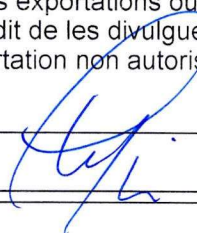
ON K6A 1K7

1

Avant que le matériel a été fabriqué, conformément, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:



Lucie Desmarais
QA Technician



DATE: 2019-04-02